Application Areas:

Water-based Polyurethane Dispersion (PUD) adhesive developed for 3D vacuum and membrane presses (Wemhöner, Bürkle etc.) for 3D thermoforming of PVC, PET, and high-gloss foils onto routed MDF kitchen doors, furniture fronts, and panels.

Ensures mirror-smooth foil surfaces without orange-peel texture and delivers 90 °C+ heat resistance along deep routed grooves. Not intended for packaging or assembly.

Characteristics & Directions for Use:

Atomizes smoothly through spray guns (1.4 – 1.8 mm nozzle) without clogging or mist spatter, creating an ultra-fine, even glue film.

Activates fully at low press temperatures of 60 – 75 °C. Heat resistance can be boosted to 110 °C+ with 5% crosslinker addition.

Processing Parameters:

Process Parameter	Specification / Condition
Press Activation Temperature	60 – 75 °C (Glue line core temperature)
Viscosity (Brookfield @ 20°C)	1,400 ± 300 mPa·s (Spindle 3 / 20 rpm)
Applied Quantity (Wet)	Flat area: 50 – 80 g/m², Routed edges: 100 – 130 g/m²
Recommended Spray Nozzle	1.4 – 1.8 mm (Gravity or pressure pot gun)
Press Cycle Time	30 – 60 seconds (4 – 6 bar vacuum/pressure)
Drying Time	20 – 35 min at room temp (Activation window: 8 hours)

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Water-Based Polyurethane Dispersion (PUD)
Density (@ 20°C)	approx. 1.06 ± 0.02 g/cm³
Solids Content	40.0 ± 1.5 %
pH Value	7.5 ± 0.5 (Neutral dispersion)
Heat Resistance	approx. 90 °C (With hardener: > 110 °C)
Appearance & Color	White Liquid (Dries clear transparent)

Performance Ratings:

3D Thermoforming Heat Resistance	**98 / 100**
Spray Atomization Quality	**99 / 100**
Deep Routing Edge Holding	**97 / 100**
Low-Temp Activation (60°C)	**95 / 100**
Mirror-Smooth Finish (No Orange Peel)	**99 / 100**

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Cleaning:

Flush spray guns and hoses with warm water immediately after use.

Storage & Shelf Life:

Store at 15 – 25 °C. PROTECT FROM FROST AT ALL TIMES! Shelf life is 9 months.

Packaging:

30 kg Plastic Pails / 1000 kg IBC Containers.

Important Remarks & Legal Notice:

Apply double cross-coats onto porous routed edges.

Protect strictly from frost.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

3D vacuum press thermo-profile audit support.

Solvent-free high-grade PUD formulation.

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